

Work Order ID 70060

Thursday, May 26, 2011 9:09:50 AM



Page 1

Item ID: D2362-7

Revision ID:

Item Name: Support Bracket

Start Date: 5/26/2011 Start Qty: 4.00

Required Date: 6/6/2011 Req'd Qty: 4.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals:

Process Plan:

Date: 10/5/11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine per folio D2362-7 Deburr

0.00

0.00

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

Handwritten signatures and dates: 11/10/07, 11/10/07, 11/10/11, 9, 0, 9, 0, 9, 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70060

Thursday, May 26, 2011 9:09:50 AM



Page 2

Item ID: D2362-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Support Bracket

Start Date: 5/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/6/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location ST WA . 0.00

Packaging

Memo

0.00

Packaging

⑨ SP 11-10-11

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

n/10/11

P. 11-10-11
⑨

W/O:		WORK ORDER CHANGES						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, May 26, 2011 9:09:57 AM

Page 1

Work Order ID: 70060

Parent Item: D2362-7

Parent Item Name: Support Bracket




Start Date: 5/26/2011

Required Date: 6/6/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B□98.12.15□Re-format, Added Inspection Levels □DM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2265  Step Bracket		Manufactured	No				Each	103.0000		4			



FK- 11/10/07

Location

Loc Qty

Loc Code

ST482

103

37477

19

44114

94

9

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WORK WITHOUT
DART

NO. 11-05-21



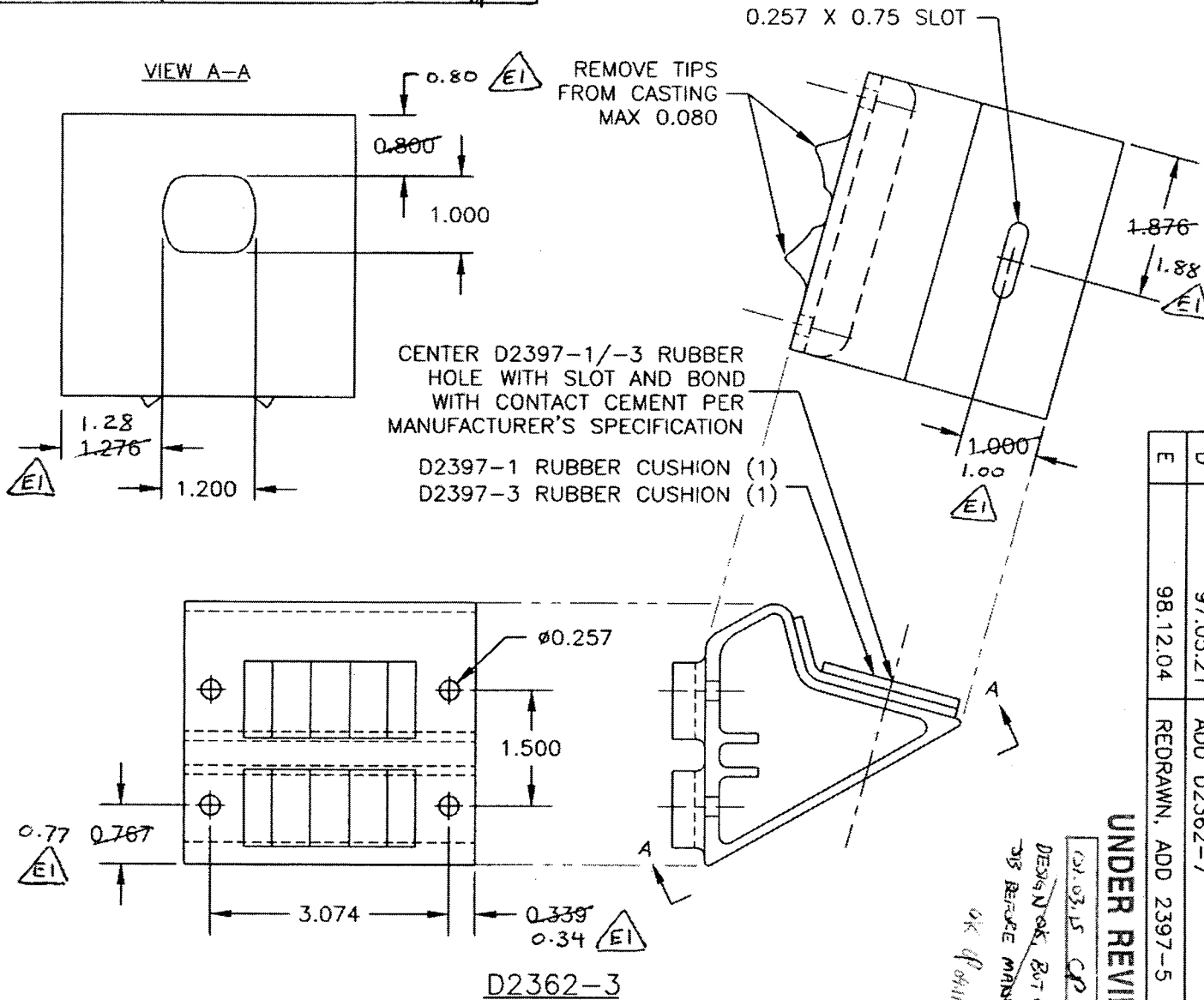
RELEASED
98.12.14 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	CP	D2362
DATE	TITLE	REV. E
98.12.04	STEP SUPPORT BRACKET	1 OF 3
A	95.02.15	NEW ISSUE
B	95.03.22	CHANGED RUBBER TO D2397
C	96.01.22	ADD D2362-5
D	97.05.21	ADD D2362-7
E	98.12.04	REDRAWN, ADD 2397-5

UNDER REVIEW

01.03.15 CP

DESIGN OK, BUT CHECK WITH
MFG BEFORE MANUFACTURE
OK 01/04/04



NOTES:

MAKE FROM D2265
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING
RUBBER IN PLACE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

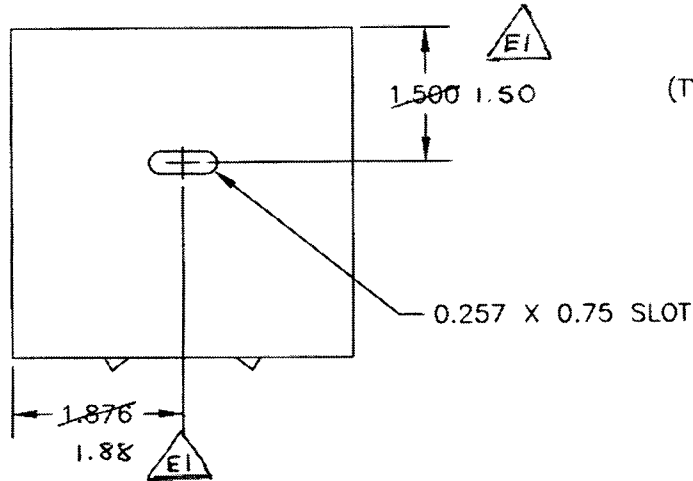
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

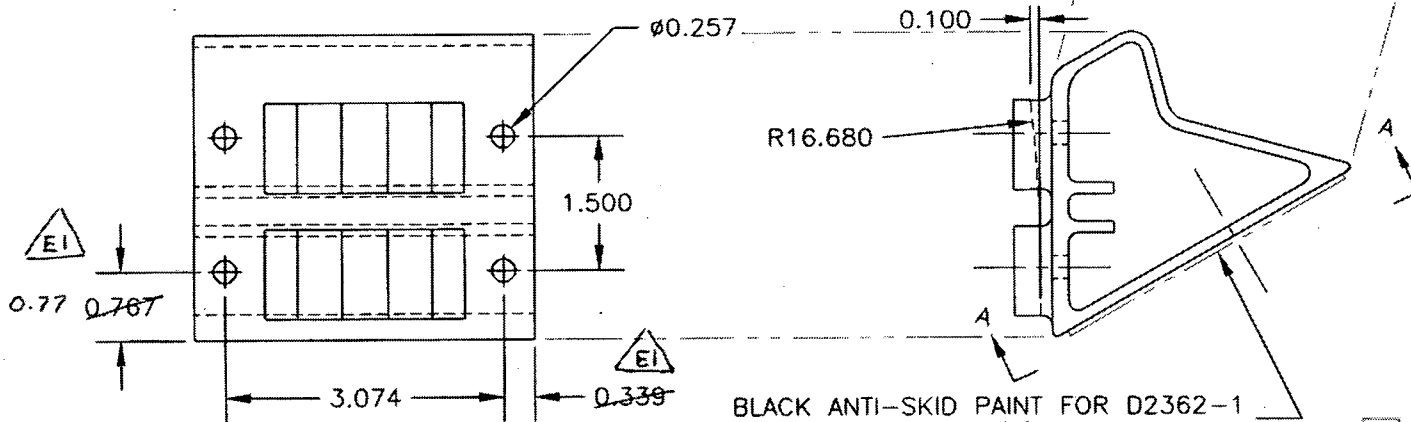
w/b 700000

VIEW A-A



MACHINE TO
R1.100
(TYP 2 PLACES)

REMOVE TIPS
FROM CASTING
MAX 0.080



BLACK ANTI-SKID PAINT FOR D2362-1
INSTALL D2397-5 (1) FOR D2362-5

D2362-1 & D2362-5

NOTES:

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT

AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

QA COPY ISSUED

DESIGN	DRAWN BY	TITLE	SCALE
BW	CP	STEP SUPPORT BRACKET	1:2
CHECKED	APPROVED	DRAWING NO.	REV. E
KE	CP	D2362	SHEET 2 OF 3
DATE			
98.12.04			

RELEASED
1998.12.14
UNDER REVIEW

DESIGNER, BUT NOT BACK BY
OR BEFORE MANUFACTURE

OK 1/10/09

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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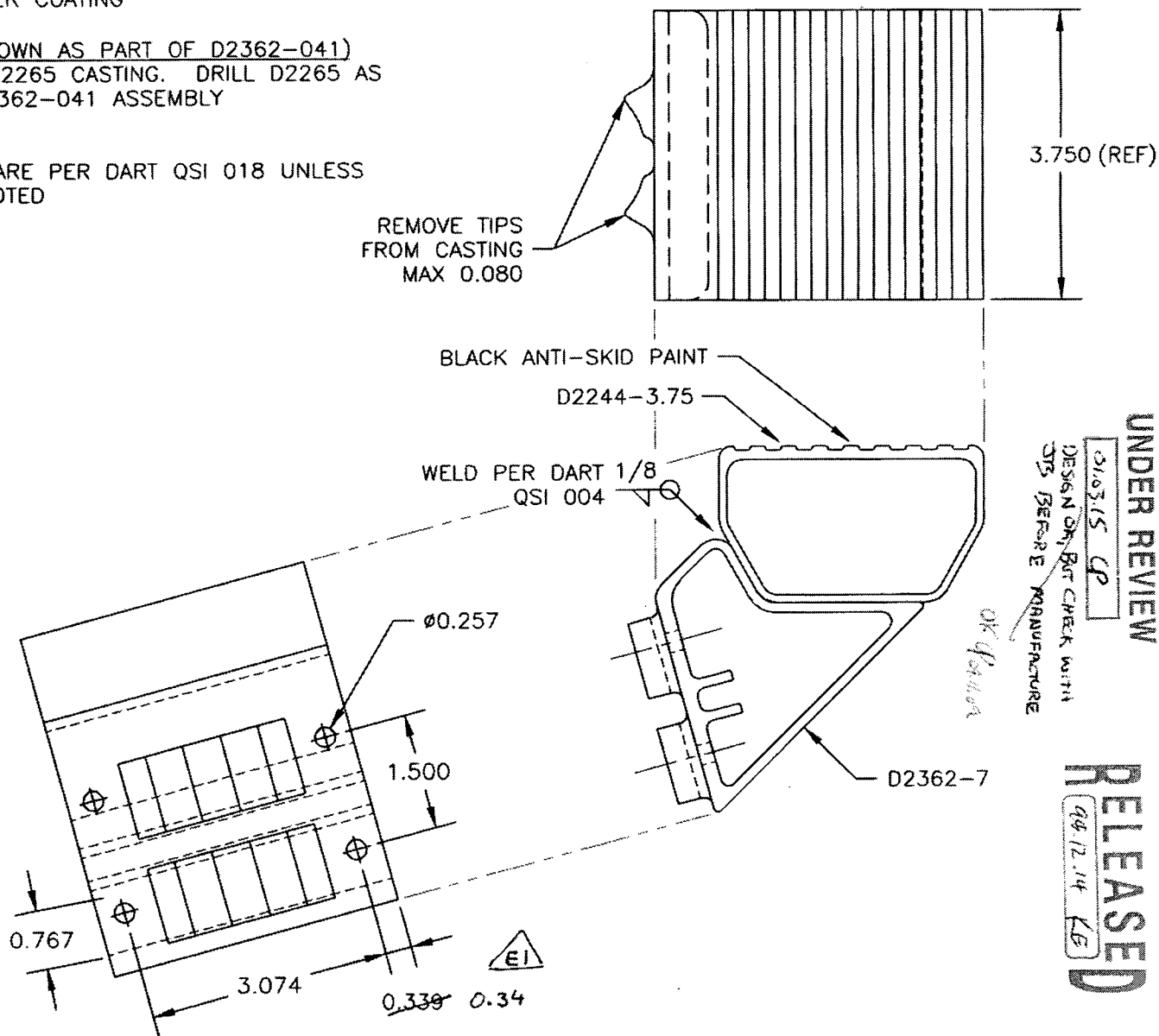
NOTE: Date & initial all entries

D2362-041 (SHOWN)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PAINT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)
MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:
TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED



DART



DESIGN	BW	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
DATE	98.12.04	TITLE	SHEET 3 OF 3
STEP SUPPORT BRACKET		SCALE	1:2

UNDER REVIEW

DESIGN OK BUT CHECK WITH
DTS BEFORE MANUFACTURE

RELEASED

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries